

Date: Tuesday, 4/25/2006 7:35:18 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number : 26789	
Estimate Number : 10831	
P.O. Number : N/A	Part Number : D29321
This Issue : 4/25/2006 S.O. No. : N/A	Drawing Number : D2932 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25637	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/15/2006 Qty: 6 Um: Each
Checked & Approved By : <u>06.04.25</u>	
Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock: 7.88
7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length
Batch No: 025348

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

SD 06.06.04

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SD 06.06.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D0732-1 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: Yes Date: 06/06/08
 QA: N/C Closed: Yes Date: 06.06.09

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.06.03	2	- chatter marks on skid tube bore. Vice came loose with vibrations. Marks too deep; Mat'l thickness under tolerance.	<u>[Signature]</u>	Scrap & replace	SA 06.06.03	<u>[Signature]</u> 06.06.05	<u>[Signature]</u> 06.06.05	<u>[Signature]</u> 06.06.05

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 26789

Part Number: D29321

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 06/06/05

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:06:06

(6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

R.M. 06-06-06

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

R.M. 06/06/07

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 479

R.M. 06/06/07

(6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/08

(6)

Job Completion



u 06-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 26789
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.120	.120	.123		
B	0.100	0.140		.120	.121	.120	.122		
C	0.100	0.140		.118	.118	.118	.122		
D	0.210	0.230		.220	.225	.224	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511					
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.239					
N	0.100	0.140		.115	.120	.120	.119		
O	0.540	0.560		.545	.544	.544	.545		
P	0.490	0.510		.499	.500	.499	.498		
Q	3.715	3.725		3.721	3.721	3.721	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.253	.253	.254		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.134	1.140	1.139	1.137		
Y	1.565	1.585		1.574	1.569	1.573	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / S.A.
Date: 06/06/02

Audited by: J.F.
Date: 06/06/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD	Work Order: 26789
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. B	Page 1 of 1

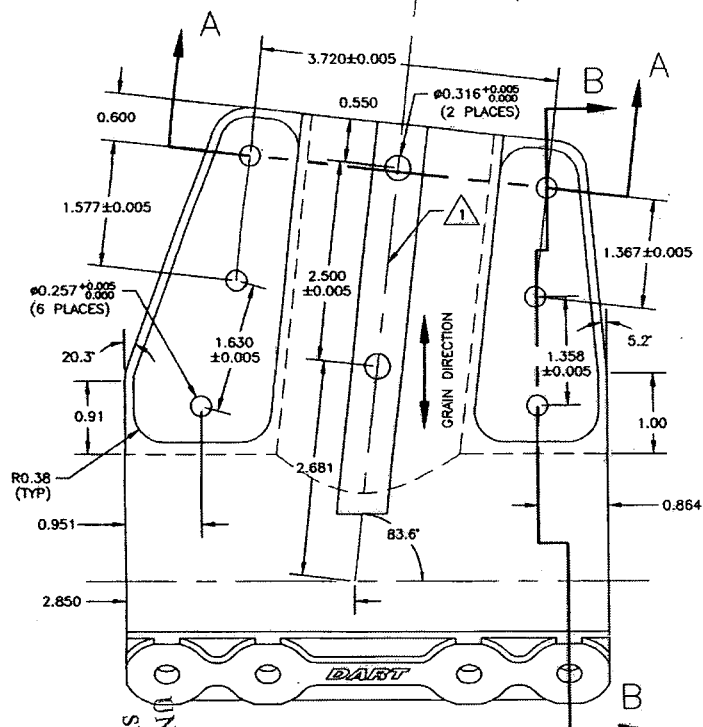
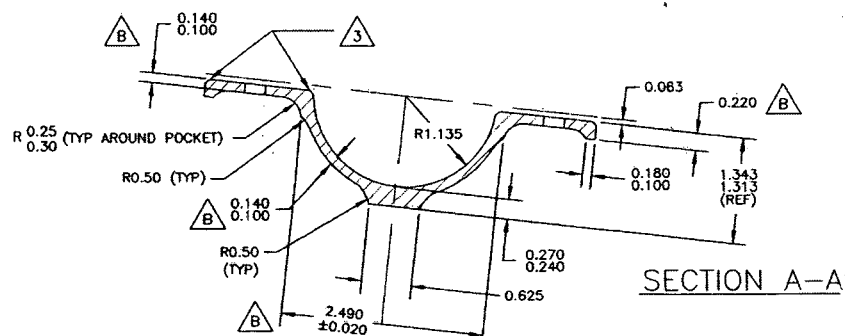
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	4	By	Date
A	0.100	0.140		.119	.121	.121			
B	0.100	0.140		.121	.122	.122			
C	0.100	0.140		.121	.122	.122			
D	0.210	0.230		.228	.226	.225			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515				.513			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505			2.500	2.500			
K	0.257	0.262	DT8683	✓					
L	0.312	0.317	DT8686	✓	✓	✓			
M	0.235	0.240				.239			
N	0.100	0.140		.122	.120	.120			
O	0.540	0.560		.543	.543	.543			
P	0.490	0.510		.499	.498	.498			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.500	2.500	2.500			
S	0.240	0.270		.254	.254	.254			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.367	1.367	1.367			
W	0.316	0.321	DT8690	✓	✓	✓			
X	1.125	1.145		1.138	1.137	1.138			
Y	1.565	1.585		1.574	1.572	1.574			
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

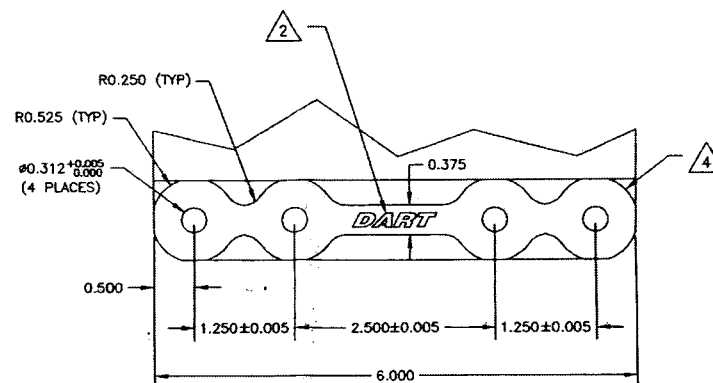
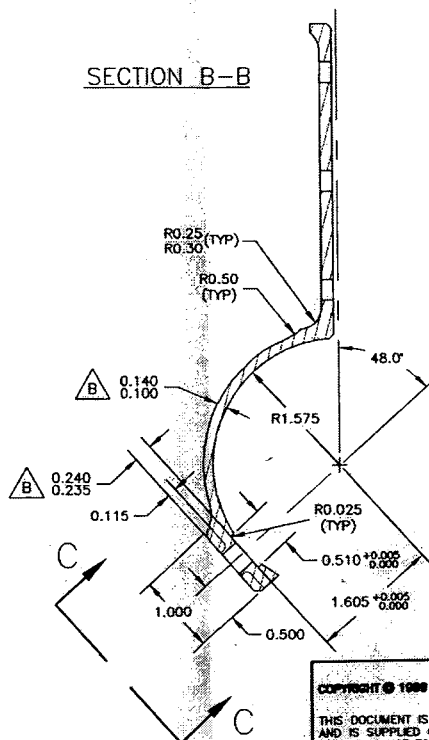
Measured by:	SD
Date:	06.06.04

Audited by:	J.L
Date:	06.06.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	✱



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
00.05.29

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE	00.05.29	TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

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